

Date: Tuesday, 23/12/2008 1:24:29 PM  
User: Linda Lacelle

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: "T" HANDLE ASSEMBLY		
Job Number	: 44314A						
Estimate Number	: 11179						
P.O. Number	:			Part Number	: D2282041		
This Issue	: 23/12/2008	S.O. No.	:	Drawing Number	: D2282 REV E		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /			Drawing Revision	: E		
Previous Run	: 44078			Material	:		
Written By	:			Due Date	: 30/01/2009		
Checked & Approved By	: <u>W</u>			Qty:	60	Um:	Each
Comment	: Est Rev:A      Removed from 9 Digit      05-12-02 JLM						
<b>Additional Product</b>							
Job Number:							
Seq. #:	Machine Or Operation:		Description :				
1.0			Tube				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) Pick: Qty Part Number      Description      Batch 1 D2282-3      Handle tube <i>B44319 = 50</i> <i>B45384 = 10</i>							
<span style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;">60</span> <i>SP 09.03.13</i>							
2.0			Tube				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number      Description      Batch 1 D2282-5      Handle tube <i>B44338 = 21</i> <i>B45385 = 39</i>							
<span style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;">21</span> <i>SP 09.03.13</i>							
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1					
							
Comment: LARGE FABRICATION RESOURCE 1							
1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282 *****brush weld right after welding, to take color off *****							
A/R ER316L SS      Filling Rod <i>M1060115</i> Dwg Rev: <i>E</i>							
<span style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;">60x</span> <i>SP 09.03.17</i>							

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 44314A

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LPL 09-03-19

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble 1B Q-3-22

6.0 QC5 INSPECT WORK TO CURRENT STEP



cont'd

Comment: INSPECT WORK TO CURRENT STEP

S 09/03/03 X60

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Saville GA

DS 09/03/04 X60

8.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/24 X60

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

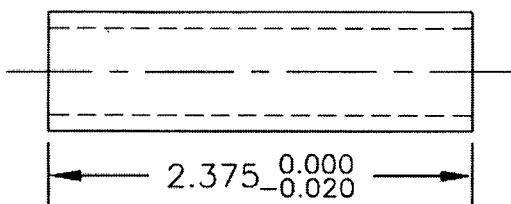
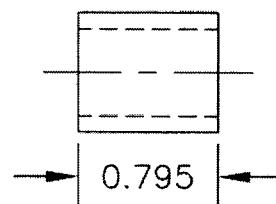
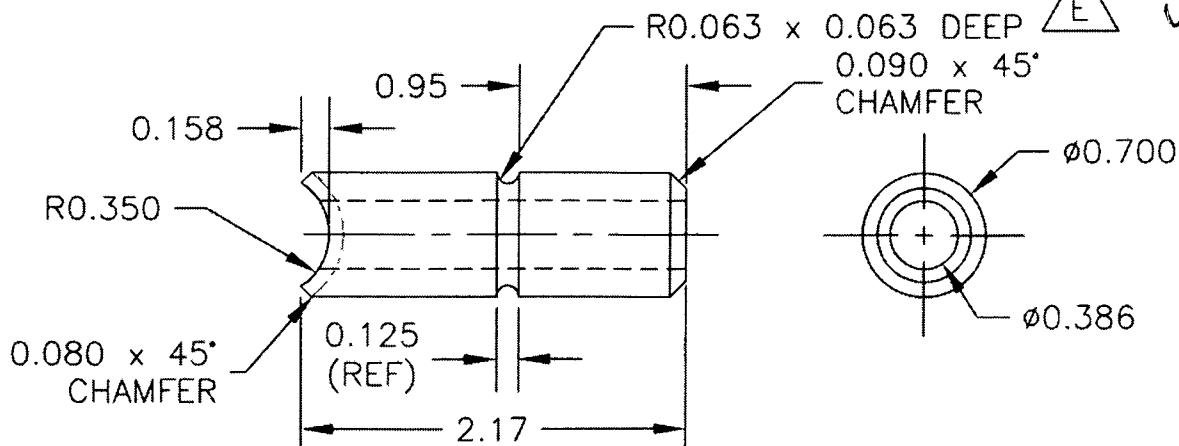
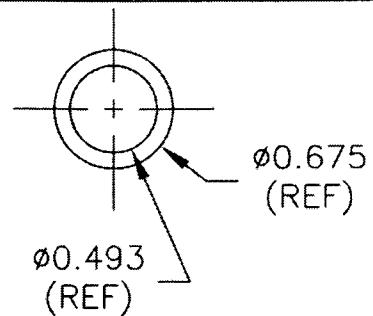


MF 09-03-04

**DART**

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Initials]</i>	APPROVED <i>[Initials]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

**RELEASED**  
*RC/09/16*

**D2282-3****D2282-7****D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**E**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

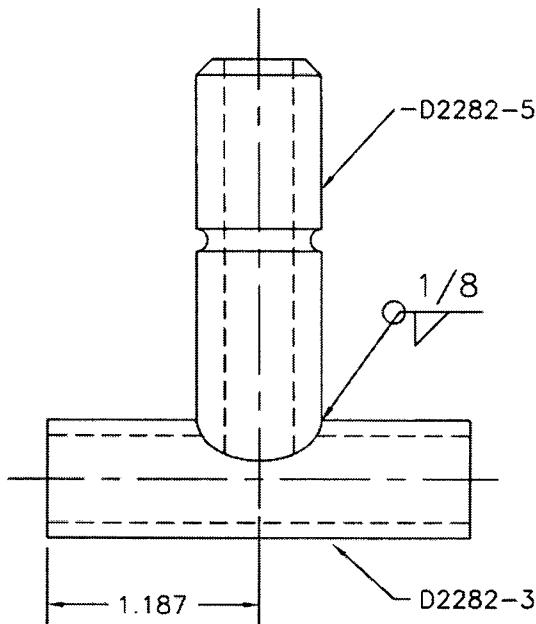
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

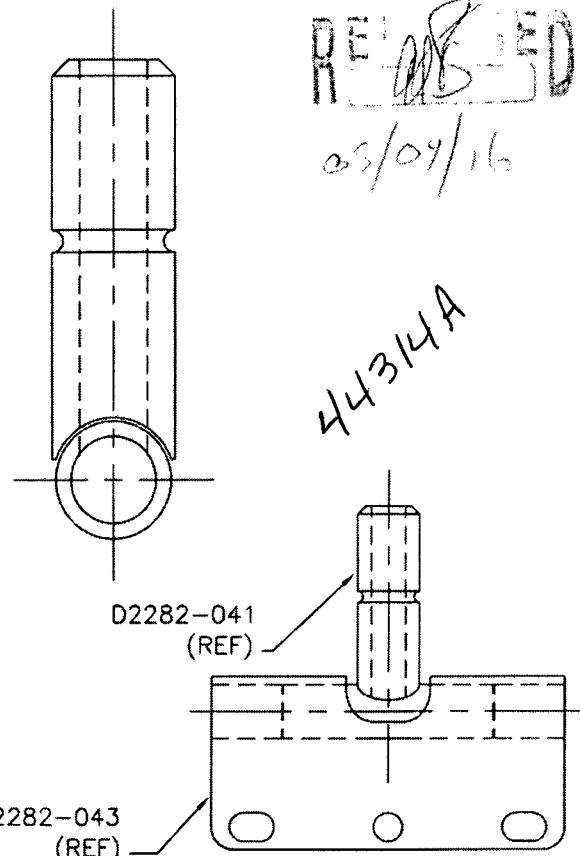
NOTE: Date & initial all entries

**DART**

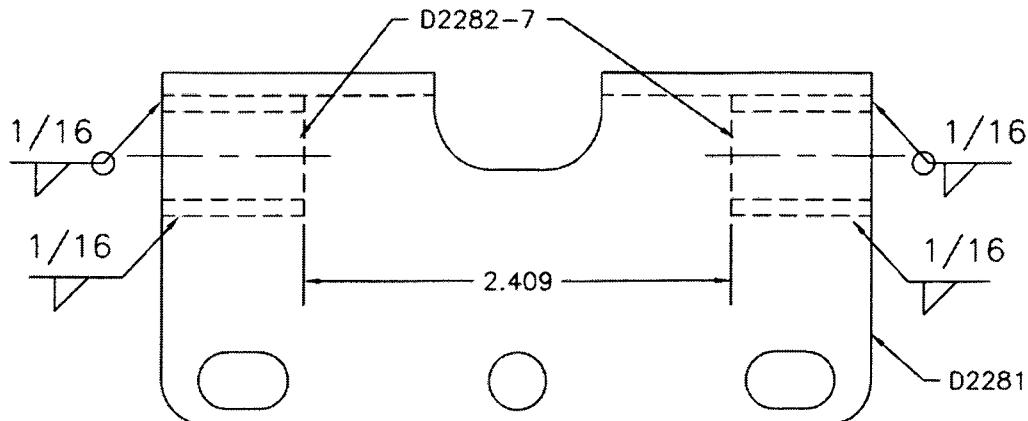
DESIGN BW	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>MM</i>	DRAWING NO. D2282
DATE 05.06.07		REV. E SHEET 2 OF 2 TITLE HANDLE TUBES SCALE 1:1



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries